

# Work Order ID 61653

Tuesday, August 31, 2010 9:50:47 AM



Page 1

Item ID: D2731-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 8/31/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: *10-8-81*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2731

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to .82"

Batch *45800*

*28 10/09/14*

*24*

*Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio FA930

DWG REV: *C*

FOLIO REV: *C*

*B.A 10/0921*

*24*

*Ø*

2-Check for crack while loading into the machine

**Work Order ID 61653**

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Page 2

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		SA 10/09/22		24	Ø		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		SA 10/09/22		24	Ø		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		BL 10-9-23		24	Ø		

**Work Order ID 61653**

Tuesday, August 31, 2010 9:50:47 AM



Page 3

Item ID: D2731-7

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Item Name: Mounting Lug

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Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

10-9-27

M 115291

Memo

0.00

START TIME:

7:45

OVEN TEMPERATURE:

320° FINISH TIME:

8:15

2H. 0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

= 1 H 10/09/27

Memo

0.00

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 470

0.00

Memo

0.00

CUT/27 04

**Work Order ID 61653**

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Page 4

Item ID: D2731-7

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Setup Start



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Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

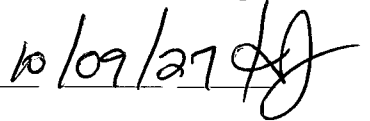


QC

Memo

0.00

Quality Control

10/09/27   
C210/9/27

# Picklist Print

Tuesday, August 31, 2010 9:50:51 AM

Page 1

Work Order ID: 61653

Parent Item: D2731-7

Parent Item Name: Mounting Lug





Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P 		Purchased	No			100	Each	0.0000	1	24			
LUG D2423 		Manufactured	No			110	f	364.5171	0.0683	1.725474			
Lug Extrusion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT06		364.5170795							
				43722		180							
				45800		184.517079							
										<u>1.7255</u>			

*S.S. 10/09/19*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

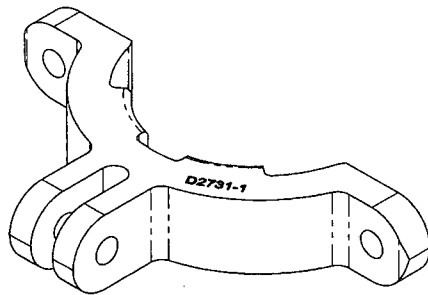
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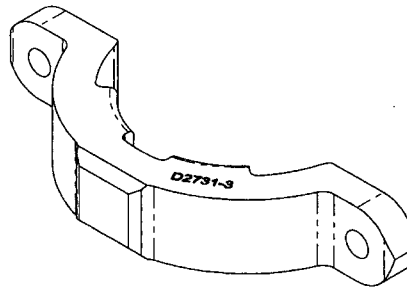
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

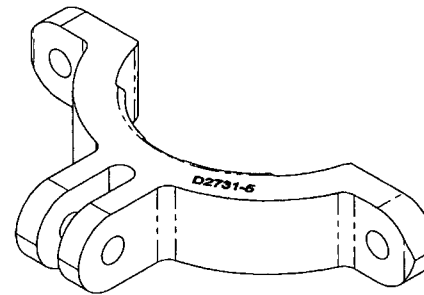
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 61653  
8810-8-31



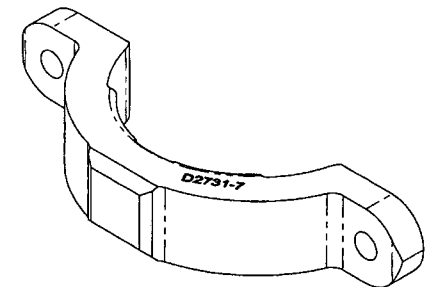
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

RELEASED  
01/24/514

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs  
 -3: 0.15 lbs  
 -5: 0.16 lbs  
 -7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



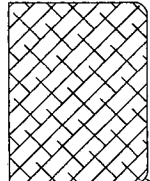
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

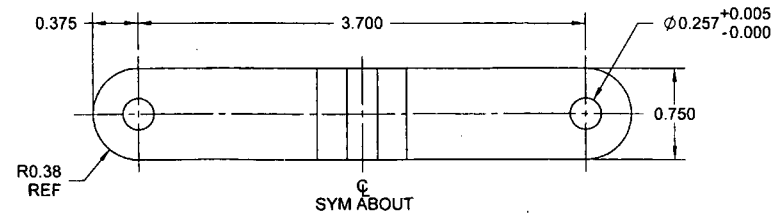
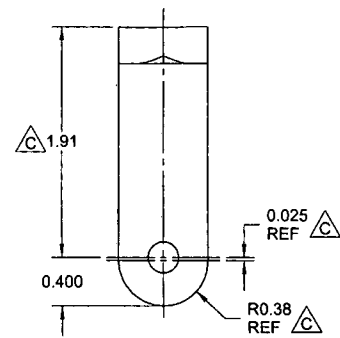
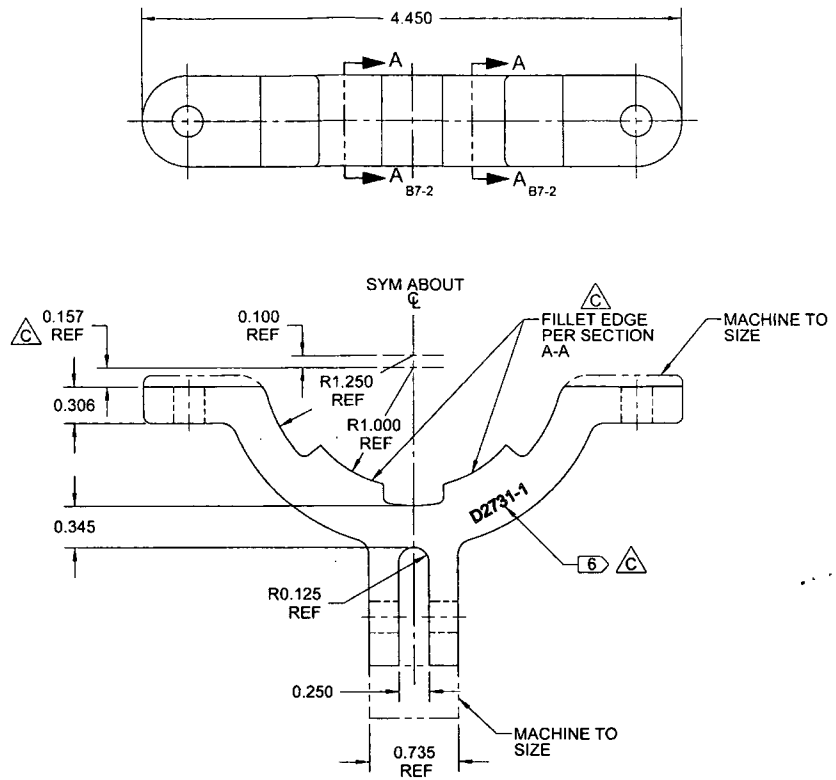
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

  
 R0.06 MIN-R0.10 MAX  
 2 PL  
**SECTION A-A** D4-2  
 SCALE 2X



**D2731-1 MOUNTING LUG**

W/061653

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09/06/25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

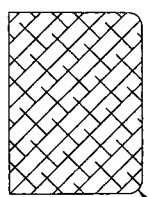
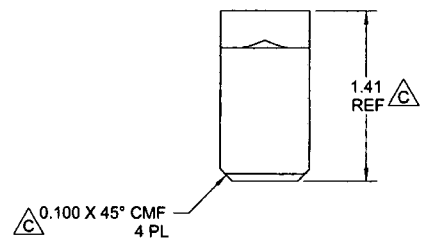
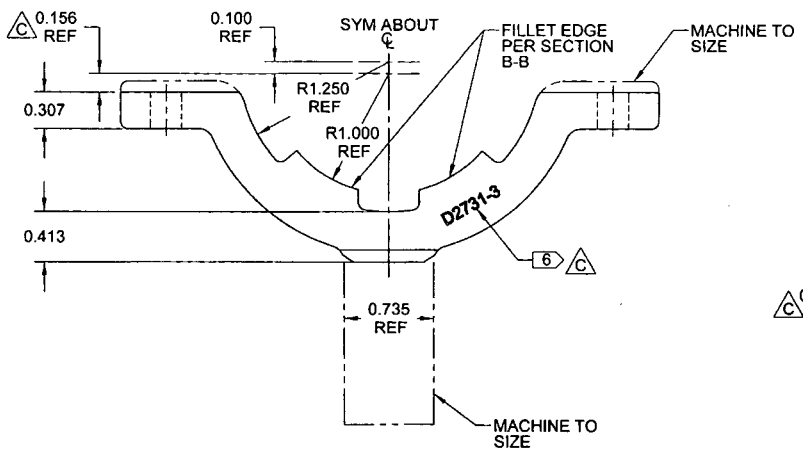
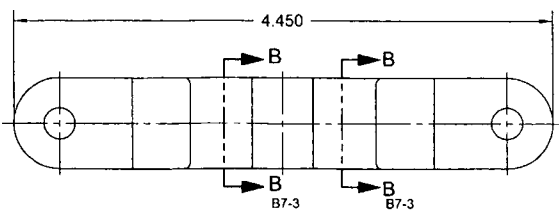
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

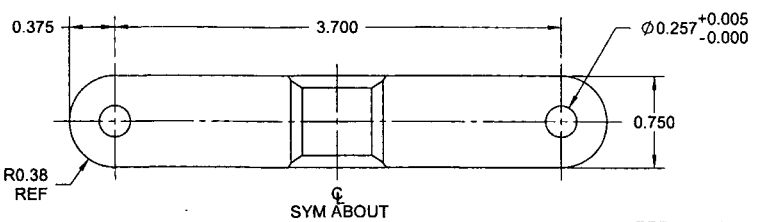
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**SECTION B-B** D4-3  
SCALE 2X

R0.06 MIN-R0.10 MAX  
2 PL



**D2731-3 MOUNTING LUG**

*W/0 616 53*

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09/25/19

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8 7 6 5 4 3 2 1

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

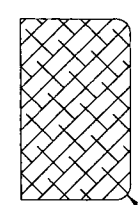
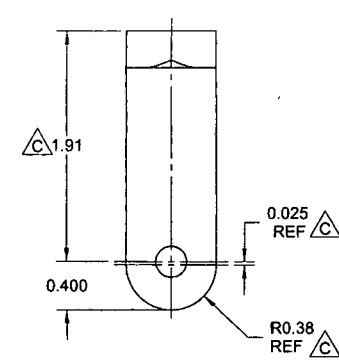
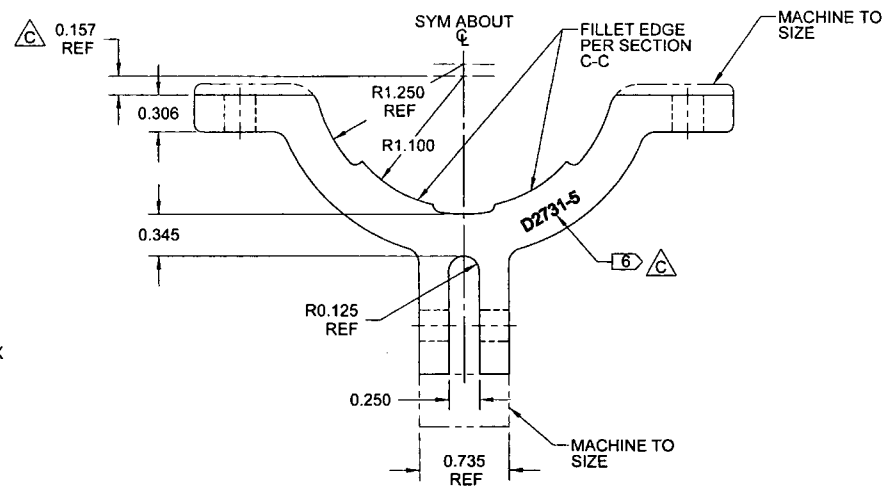
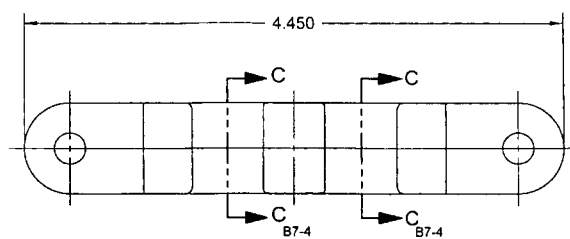
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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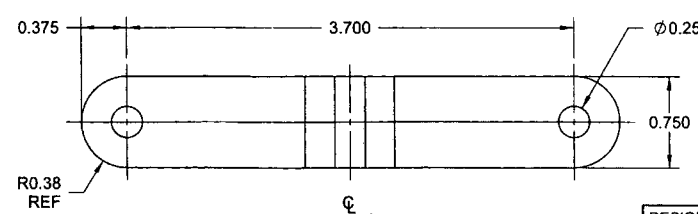
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**SECTION C-C** D4-4  
SCALE 2X

R0.06 MIN-R0.10 MAX  
2 PL



**D2731-5 MOUNTING LUG**

W10 61653

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

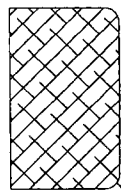
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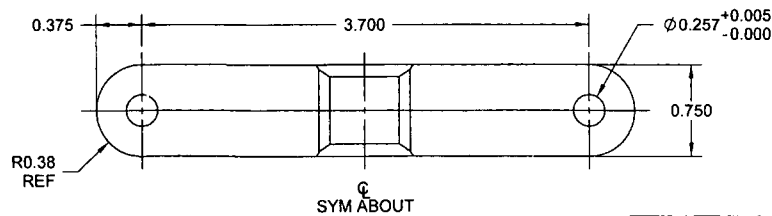
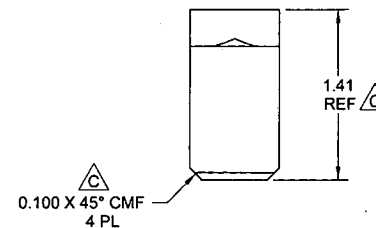
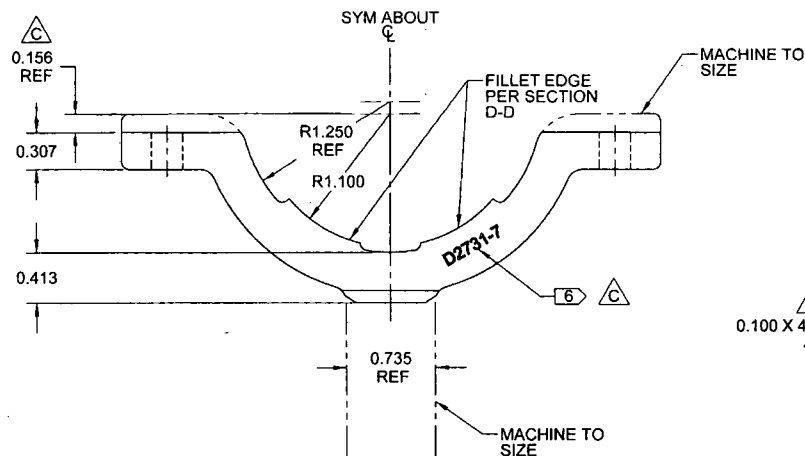
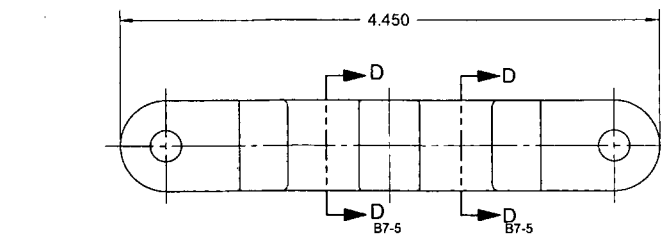
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**SECTION D-D** D4-5  
SCALE 2X



R0.06 MIN-R0.10 MAX  
2 PL



**D2731-7 MOUNTING LUG**

W/O 66653

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09/06/25/11

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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